

Work Order ID 109150

Tuesday, November 12, 2013 8:37:53 AM

109150

Page 1

Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/13/2013 Req'd Qty: 1.00

1

Customer:

Reference: rework

Approvals: Process Plan: *MF*Date: *13-11-12*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2351-042

E

330

0.00

DAS
31
9-89*13-11-13**(1)****330***

Small Fab

Small Fab

Memo

pull from stock d350-591-122 x 1 b88950

used for trial fit

part needs touch ups and new kit

0.00

13-11-11

340

0.00

340

Powdercoat

Powder Coating

Memo

touch up where necessary

0.00

13-11-12

DART AEROSPACE		1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartaero.com	
PATENT	N/A	CHG	CHG005
P.N.	D350-591-122	STC	SH92-6
DESC	Heli-Access-Step.RH	STC	SH967NE
LOT	B88950	STC	
MODEL	AS350/355	STC	
TC APPROVAL # 09-89		MADE IN CANADA D2729-4	

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Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/13/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

350

QC3- Inspect Part Finish

0.00

350

QC

Memo

0.00

Quality Control

360

Pick Kit

0.00

360

Packaging

Memo

0.00

Packaging

370

QC4- 100% Inspect kits for completeness

0.00

370

QC

Memo

0.00

Quality Control

1 ~~13-11-12~~ ~~13-11-12~~

1X DAS 28 13-11-12 9-89

13/4/13

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Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/13/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

380

Identify as per dwg & Stock Location: _____

0.00

380

Packaging

Memo

0.00

Packaging

①

DAS
6
9-8g

13/11/13

Z

390

QC21- Final Inspection - Work Order Release

0.00

390

QC

Memo

0.00

Quality Control

MLJ

13-11-13

MK

13-11-13

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Page 1

Work Order ID: 109150

Parent Item: D350-591-122

Start Date: 11/11/2013

Required Date: 11/13/2013

Parent Item Name: Heli-Access-Step™ RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-37A Bolt		Purchased	No				Each	255.0000	DAS 6 9-89	2		DAS 28 9-89	13-11-12
DAS 31 9-89				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		10							
				119086		10							
				ST513		245							
				123355		245							
AN4-13A Bolt		Purchased	No				Each	1,132.0000	DAS 6 9-89	3		DAS 28 9-89	
DAS 31 9-89				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		20							
				122808		20							
				ST356		50							
				m127432		50							
				ST511		993							
				m126193		993							
				ST514		69							
				m125709		69							
AN4-16A Bolt		Purchased	No				Each	275.0000	DAS 6 9-89	2		DAS 28 9-89	
DAS 31 9-89				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		5							
				121541		5							
				ST357		108							
				124215		8							
				M127432		100							
				ST514		162							
				125427		115							
				M126073		47							

Picklist Print

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Page 2

Work Order ID: 109150

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013

Required Date: 11/13/2013

Start Qty: 1.00

Required Qty: 1.00

D2230-1

Mounting Lug

Manufactured No

Each 221.0000

DAS
31
9-89

DAS
28
9-89

DAS
28
9-89

13-11-12

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	4	
84136	4	
GA	12	
101834	12	IX
ST469	205	
101834	19	
102280	48	
89783	16	
95217	120	
96247	2	

D2230-3

Mounting Lug

Manufactured No

Each 130.0000

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	4	
89045	4	
ST469	126	
101495	4	
102326	96	IX
89782	19	
90514	1	
94957	2	
97815	2	
97903	2	

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Shop Packet Print

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Work Order ID: 109150

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013

Required Date: 11/13/2013

Start Qty: 1.00

Required Qty: 1.00

~~D2732-030~~

Manufactured No

Each 210.0000

Rubber Cushion (Replaces P/N G13013-4)

DAS
31
9-89

act(2)
at 3.00"

Location

Loc Qty

Loc Code

FG	92	
101857	18	
83560	24	
94725	45	
98629	5	
ST127	118	
102705	2	
104906	30	
105477	86	

DAS
31
9-89

2

DAS
28
9-89

13-11-12

B107346

~~D2856-400-720~~

Manufactured No

f 165.9992

Abrasion Strip 4" Wide (Per Foot)

DAS
31
9-89

Location

Loc Qty

Loc Code

ST408	124.5252632	
101773	119.16	
99378	5.36526316	
ST415	41.4739	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	

DAS
31
9-89

0.6

DAS
28
9-89

B107810

~~D350-591-122~~

Manufactured No

Each 1.0000

Heli-Access-Step™ RH

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	1	
71548	1	

DAS
31
9-89

1

1 x 8890

mk 13-11-12

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Page 4

Work Order ID: 109150
Parent Item: D350-591-122
Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013

Required Date: 11/13/2013

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

Each 7,762.0000

Nut

DAS
28
9-89

13-11-12

DAS
31
9-89

Location	Loc Qty	Loc Code
ST314	1035	
M126036	35	
M127304	1000	
ST506	814	
123900	814	
ST509	3000	
M127410	3000	
ST510a	2913	
M126275	8	
M126333	2905	

2x

MS21042L4

Purchased No

Each 5,814.0000

Locknut

DAS
28
9-89

DAS
31
9-89

Location	Loc Qty	Loc Code
FP001	50	
122452	38	
8182	12	
ST314	9	
m125708	9	
st507	33	
m126073	33	
ST509	5331	
m123376	2000	
m126275	1355	
m127255	1976	
ST510a	233	
m126333	233	
ST518	158	
124231	158	

3x

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Picklist Print

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Work Order ID: 109150

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013

Required Date: 11/13/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased No

Each 4,908.0000

Washer

DAS
28
9-89

13-11-12

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001	1	
123248	1	
ST294	230	
113068	11	
124392	219	
ST510a	4677	
m126319	4677	

NAS1149D0463J

Purchased No

Each 2,291.0000

WASHER

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001	2	
122441	2	
ST007	24	
121912	24	
ST294	1547	
119097	1	
124198	35	
124778	83	
M127255	1428	
ST510a	718	
M126221	718	

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List Lots

Monday, November 11, 2013 3:48:31 PM

Page 1 of 1

Criteria : Item ID: d350-591-122 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D350-591-122 Heli-Access-Step™ RH	Main Warehouse FG060	71548	9/19/2012	0.0000	QC21	CHG005	
	Main Warehouse FG061	88950	11/7/2013	1.0000	QC21	CHG005	
	OFFSHORE FG	71548	11/7/2012	1.0000	QC21	CHG005	
	Total:			2.0000			

109150

5. PARTS LIST

REFERENCE ONLY
SL 13-11-L3

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G
Date: 08.10.06

REFERENCE ONLY

13-11-13

8

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step ™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.







Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
DATE	09.06.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Item ID: D350-591-122

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 11/11/2013 Start Qty: 1.00

Required Date: 11/13/2013 Req'd Qty: 1.00

Reference: rework

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MF

QC:

Date: 11-11-12

Tooling:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID Operation
Description

Draw Nbr Revision Nbr

D2351-042

E

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

330

330

Small Fab

Small Fab

0.00

Memo

pull from stock d350-591-122 x 1 b88950

used for trial fit

part needs touch ups and new kit

0.00

340

340

Powdercoat

Powder Coating

0.00

Memo

touch up where necessary

0.00

13-11-11

13-11-12